

Work Order ID 51562

August 26, 2009 10:17:24 AM

ASAP



PRELIMINARY ISSUE

Page 1

Item ID: D3956-1
Revision ID: A-PRELIM
Item Name: Hinge, Airframe Upper

Accept



Setup Start



Stop



Start Date: 8/26/09 Start Qty: 1.00
Required Date: 8/27/09 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:
QC:

[Signature]

Date:

Tooling:

Date:

Run Start





Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3956	A-PRELIM								
100		0.00							
									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3956 Dwg Rev: <u>QRF</u> Prog Rev: <u>Lim</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
									
QC	Memo	0.00							
Quality Control									

LB 9-8-26

LB 9-8-26

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Accept



Setup Start



Stop



Start Date: 8/26/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/27/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

08-08-27

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

09/08/22 1 0

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

Start Time: _____
Oven Temperature: _____
Finish Time: _____

N/A per ECN 09-6508

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Setup Start



Stop



Start Date: 8/26/09 Start Qty: 1.00
Required Date: 8/27/09 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

BR 09-08-27 ①

SHIP TO HARVEY AT EAGLE - see Hake email

*TESTING ONLY
NO AC 21 / NO C of C*

R003091113

POSITIVE RECALL

EFFECTIVE

9/8/06

AUTH

U

RELEASED

DATE

09.08.27

Picklist Print

August 26, 2009 10:17:24 AM

Page 1

Work Order ID: 51562



Parent Item: D3956-1A-PRELIM



Parent Item Name: Hinge, Airframe Upper

Start Date: 8/26/09

Required Date: 8/27/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.250		Purchased	No			100	sf	0.0000	0.1801			

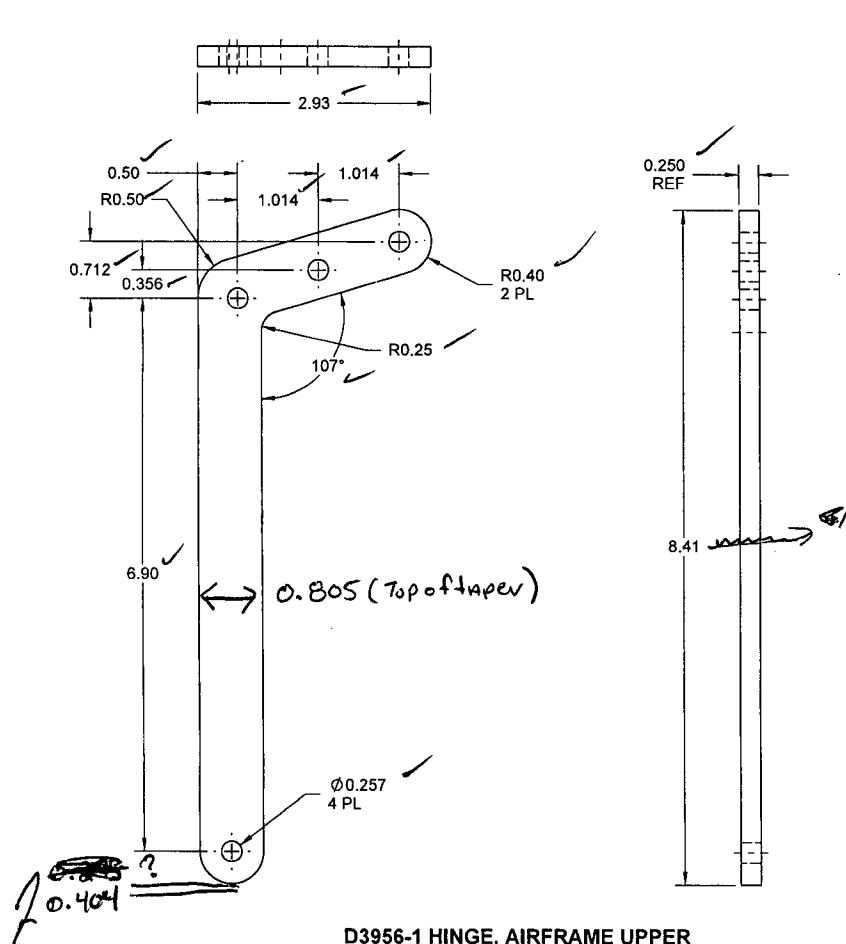


6061T6 SHEET .250



m18398 13 9-8-26

Bar used
6061T6 B0.250x3.500



PRELIMINARY ISSUE
 09/08/25

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.250 THICK
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
 REF DART SPEC M6061T6S.250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3956-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.19 lbs

A		NEW ISSUE		09.08.24	
REV.		DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN					
CHECKED					
MFG. APPR.					
APPROVED					
DE APPR.		HINGE			
DATE	09.08.24	COPYRIGHT © 2009 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

L Lacelle

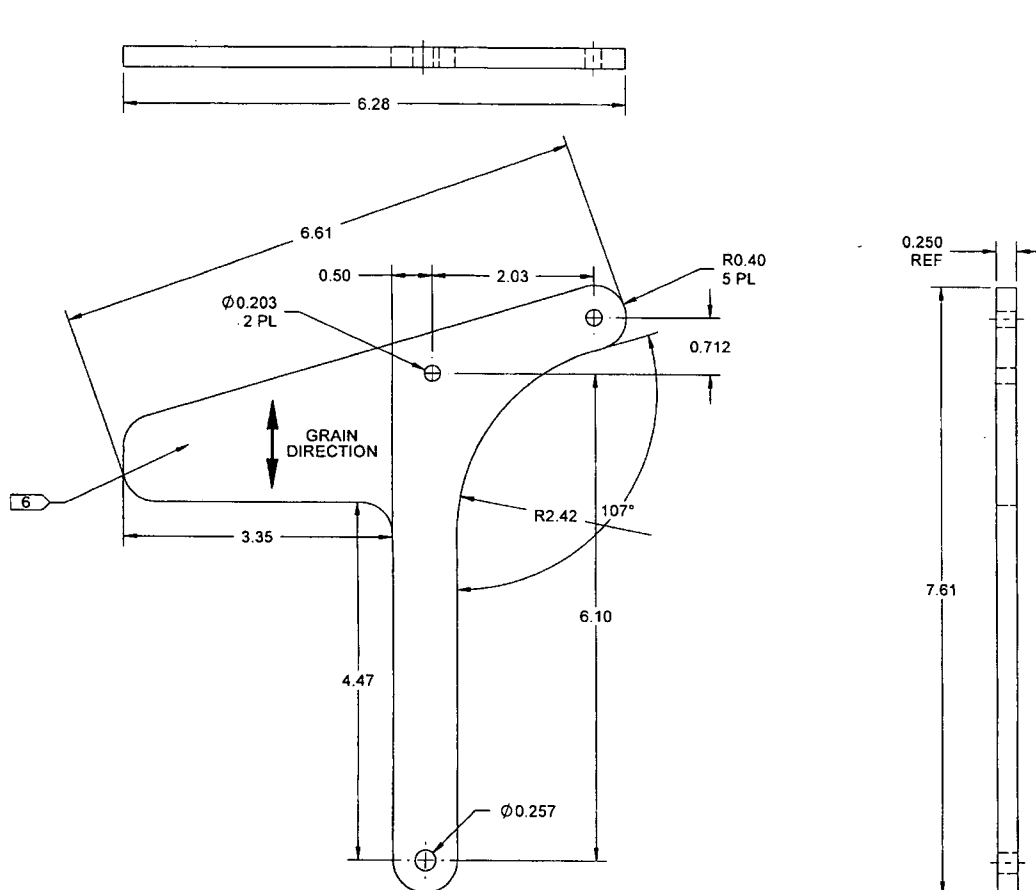
From: Mike Petsche [mpetsche@dartaero.com]
Sent: August 27, 2009 12:44 PM
To: 'L Lacelle'; 'Harvey Siemens'
Cc: ssheldon@dartaero.com; 'Jason Murdoch'
Subject: RE: D3956-1/-3 hinges

They can go +ve recall....they are staying within DART control. For testing only. Dwgs aren't released or anything

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Thursday, August 27, 2009 11:18 AM
To: 'Mike Petsche'; 'Harvey Siemens'
Cc: ssheldon@dartaero.com; 'Jason Murdoch'
Subject: D3956-1/-3 hinges
Importance: High

I have 1 each of these to ship to you Harvey, and are under positive recall...is this how we are sending them out?
I know these are rush so would need to know asap, and are there other parts to go with these?

Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd



D3956-1 HINGE, AIRFRAME UPPER

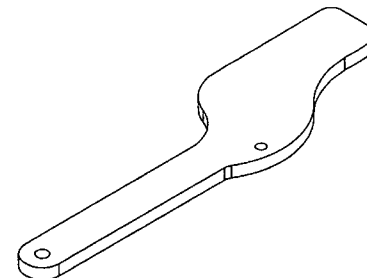
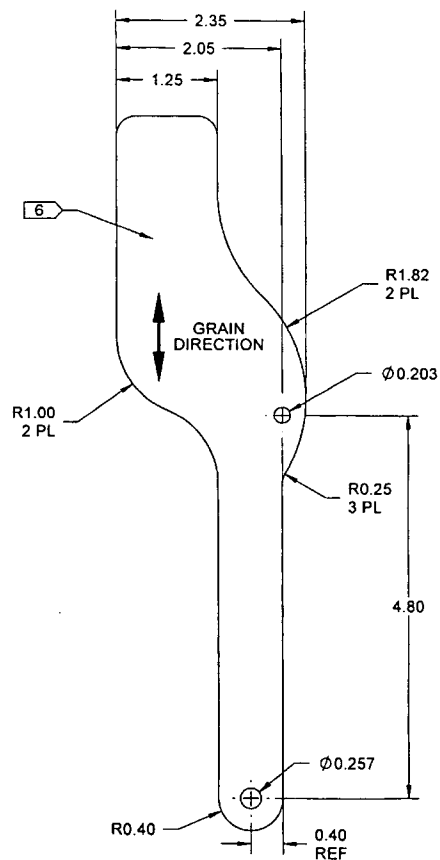
NOTES:

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PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.250
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POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3956-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.31 lbs

RELEASED
2009-10-08
JMT

REV.	NEW ISSUE	DESCRIPTION	BY	DATE
DESIGN				
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APPROVED				
DE APPR.				
DATE	09.09.14			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWING NO. D3956	SHEET 1 OF 2
TITLE HINGE	SCALE NTS
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51562

RELEASED
2009-10-08
NNT

D3956-3 HINGE, AIRFRAME LOWER

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.250 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3956-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.25 lbs

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3956	SHEET 2 OF 2
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